

# Work Order ID 81115

**\*81115\***

Page 1

March-08-12 8:51:57 AM

Item ID: D3391-025 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Tube Assembly  
 Start Date: 08/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 22/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/09 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	I

100 0.00

**\*100\***

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: A & Dwg D3391 Rev: I

\*\*\*scribe batch # on fwd end at 90 degree\*\*\*

*manl 12/03/10*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*manl 12/03/20*

111

QC8- Inspect parts - second check

0.00

**\*111\***

QC

Memo

0.00

Quality Control

\*\*\*INSPECT INSIDE BORE\*\*\*

*manl 12/03/23*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1  Memo 1-Machine as per Folio FA 599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>I</u> 2-Deburr	0.00  0.00							
			SL 12/03/23						man.l 12/03/20
130 <b>*130*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00							
			SL 12/03/23						man.l 12/03/20
140 <b>*140*</b> QC Quality Control	QC8- Inspect parts - second check  Memo ***INSPECT INSIDE BORE***	0.00  0.00							
			SL 12/03/23						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 81115****\*81115\***

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March-08-12 8:51:57 AM

Item ID: D3391-025  
Revision ID:  
Item Name: Aft Tube Assembly

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***Start Date: 08/03/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Skidtubes	0.00							
<b>*150*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160	BENDING MACHINE - SKIDTUBES	0.00							
<b>*160*</b>									
CNC Bend I	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170	QC5- Inspect part completeness to step on W/O	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

CF 12-3-27

R 12/03/27

DP 12-3-27

4.025"

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 81115****\*81115\***

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March-08-12 8:51:57 AM

Item ID: D3391-025

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Tube Assembly

Start Date: 08/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject -  
NumberInsp.  
Stamp

180

0.00

**\*180\***

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391 (Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878 (Mid Tube) & DT8217  
Wearplate Jig.

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2  
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297" and float bag holes to 0.328" as per  
Dwg D3391

7-Deburr

DC 12/04/04

DC 12/04/10

DC 12/04/10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 08/03/2012    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 22/03/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **SPC (Y/N):** \_\_\_\_\_      **Date:** \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

[illegible]

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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March-08-12 8:51:57 AM

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Item Name: Aft Tube Assembly  
Start Date: 08/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 22/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*240*</b> Powdercoat Powder Coating	Memo START TIME: 8:40 OVEN TEMPERATURE: 320°F FINISH TIME: 9:10	0.00				1X	✓		M.L. 12/04/17
250	QC3- Inspect Part Finish	0.00							
<b>*250*</b> QC Quality Control	Memo	0.00				1X	✓		12/04/17
260	HandFinishing	0.00							
<b>*260*</b> HandFinish Hand Finishing	Memo 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 11/21/22 Sikaflex expiry date: 13/01/17 3- INSTALL WEARPLATES AS PER DWG	0.00				1X	✓		12/04/17

M 121134

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 81115**

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Item ID: D3391-025

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Tube Assembly

Start Date: 08/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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270

QC5- Inspect part completeness to step on W/O

0.00

**\*270\***

QC

Memo

0.00

Quality Control

280

Identify as per dwg & Stock Location: w/o

0.00

**\*280\***

Packaging

Memo

0.00

Packaging

290

QC21- Final Inspection - Work Order Release

0.00

**\*290\***

QC

Memo

0.00

Quality Control

S. 26/08

D412-742-043/1379962

21 d 12/10/08

12/5/9

ME

12-05-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

March-08-12 8:52:00 AM

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Work Order ID: 81115

\*81115\*

Parent Item: D3391-025

\*D3391-025\*

Parent Item Name: Aft Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC  
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM  
 IPP rev D 07.03.20 revF dwg EC  
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD  
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC  
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H  
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4095-047		Manufactured	No			260	Each	19.0000	1	1			
<b>*D4095-047*</b> Wearpad Assembly													
<div style="display: flex; justify-content: space-between;"> <div> <b>**</b>            JH 12/04/26         </div> </div>													

Location	Loc Qty	Loc Code
FP002	19	
78325	5	
80703	14	

D4095-049		Manufactured	No			260	Each	15.0000	1	1			
<b>*D4095-049*</b> Wearpad Assembly													
<div style="display: flex; justify-content: space-between;"> <div> <b>**</b>            JH 12/04/26         </div> </div>													

Location	Loc Qty	Loc Code
FP002	15	
80704	15	

D6014-090		Manufactured	No			100	Each	43.0000	1	1			
<b>*D6014-090*</b> ALUMINUM EXTRUSION													
<div style="display: flex; justify-content: space-between;"> <div> <b>**</b> </div> </div>													

Location	Loc Qty	Loc Code
LG	43	
77332	43	

JH 12/03/12

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Work Order ID: 81115

**\*81115\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

63.0000

4

4

**\*D3670-4-200\***

SPACER

\*\*

12/04/11

Location

Loc Qty

Loc Code

LG001

63

72851

3

77500

4

78606

56

D2646

Manufactured No

270

Each

146.0000

1

**\*D2646\***

Aft Cap

\*\*

12/04/12

Location

Loc Qty

Loc Code

FP002

146

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

33

79500

47

79562

50

D3672-1

Manufactured No

270

Each

1,294.000

2

2

**\*D3672-1\***

Phenolic Washer

\*\*

12/04/12

Location

Loc Qty

Loc Code

FP001

242

66821

242

ST060

1052

72229

52

76277

500

80369

500

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Shop Packet Print

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Dart Aerospace Ltd

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

\*81115\*

\*D3391-025\*

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

4,855.000

14

14

\*AI S4-1032-130\*

Insert

\*\*

HL 12/04/26

## Location

## Loc Qty

## Loc Code

ST280

681

119084

116

120671

565

ST281

4174

120410

174

120807

2000

120837

2000

Y/L

ALS4-1032-225

Purchased

No

270

Each

1,194.000

8

8

\*AI S4-1032-225\*

Insert

\*\*

HL 12/04/22

## Location

## Loc Qty

## Loc Code

ST281

1031

108696

146

110768

62

118386

55

118966

68

120671

700

M121269

X<sup>0</sup>

ST282

163

120410

150

120451

13

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Dart Aerospace Ltd

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Parent Item Name: Aft Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

270 Each 3,729.000 6 6

\*AN3C4A\*

BOLT

\*\*

HL 12/04/12 6

## Location

## Loc Qty

## Loc Code

ST350

3729

117688

5

118112

16

119749

10

120187

2000

120423

10

120521

510

120769

515

120799

163

120930

500

V6

AN3C5A Purchased No

270 Each 1,010.000 4 4

\*AN3C5A\*

Bolt

\*\*

HL 12/04/12 6

## Location

## Loc Qty

## Loc Code

FP001

7

115835

7

ST350

1003

116419

28

117343

13

117764

7

117872

2

119749

23

120423

930

M1210168

X4

AN960C10L NAS1149C0332 Purchased No

270 Each 0.0000 10 10

\*AN960C10I \*

washer

\*\*

M121509 (x10) HL 12/04/12 6

March-08-12 8:52:00 AM

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Dart Aerospace Ltd

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 81115
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> H <i>[Signature]</i>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<b>Lathe Section</b>						
14.000	+/-0.010	14.000	/		tape	mm, L-02
3.500	+/-0.010	3.501	/		vern	CWL-06
88.93	+/-0.030	88.93	/		tape	mm, L-02
Ø3.200	+/-0.010	3.199	/		vern	CWL-06
88.93	+/-0.030	88.93	/		tape	mm, L-02
Ø3.750	+/-0.010	3.750	/		vern	CWL-06
30° x 160" chamfer	+/-0.010	30° x 160"	✓		"	

<b>Measured by:</b> <i>[Signature]</i>	<b>Date:</b> 12/03/17
<b>Audited by:</b>	<b>Date:</b>

<b>HAAS Section</b>						
1.526	+0.000/-0.030	1.520	/		vern	SD3
7.500	+/-0.010	7.501	/		"	
27.750	+/-0.010	27.750	/		m-tape	
31.750	+/-0.010	31.750	/		"	
35.250	+/-0.010	35.250	/		"	
3.300	+/-0.010	3.300	/		vern	"
0.200	+/-0.010	0.202	/		"	
3.520	+/-0.010	3.524	/		"	
0.687	+0.010/-0.000	0.690	/		"	
R0.062	+/-0.010	0.062	/			
Ø0.484	+0.005/-0.001	0.484	/		"	

<b>Measured by:</b> <i>[Signature]</i>	<b>Date:</b> 12/03/23
<b>Audited by:</b> <i>[Signature]</i>	<b>Date:</b> 12/03/23

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	<i>[Signature]</i>

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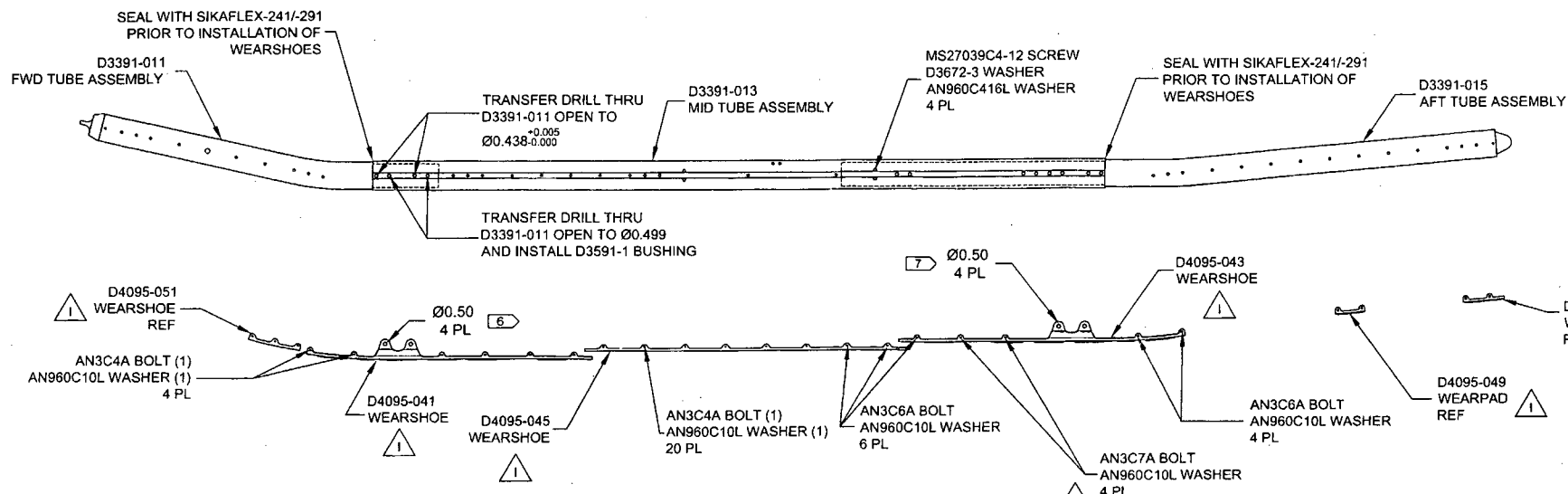
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

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**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCRYON"  
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> KENT, WA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 1 OF 8
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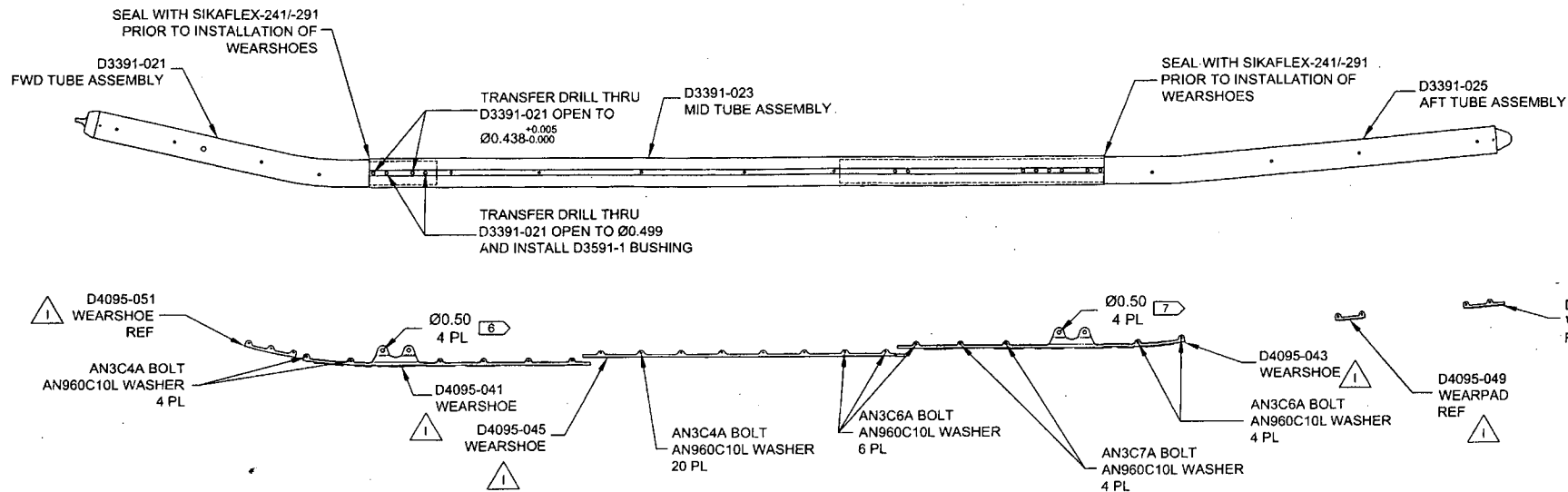
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#### D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

#### GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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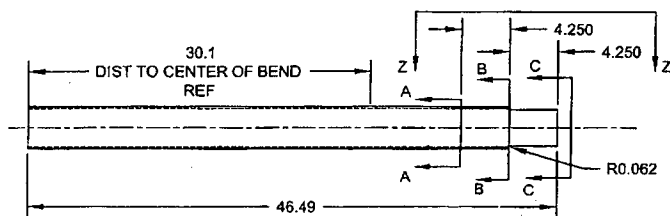
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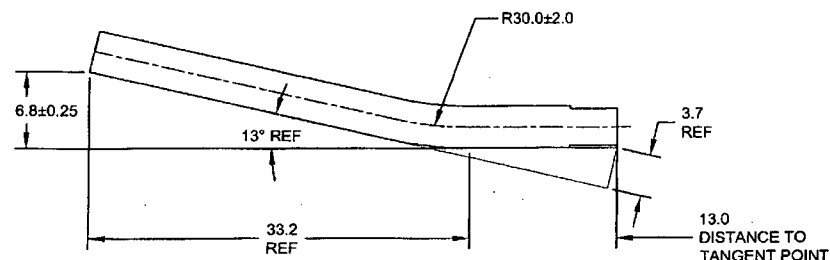
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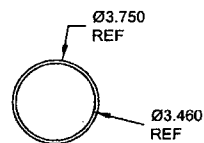
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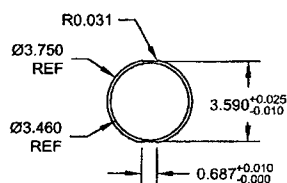
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



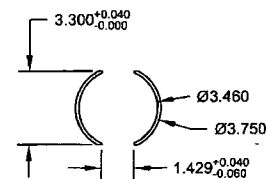
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



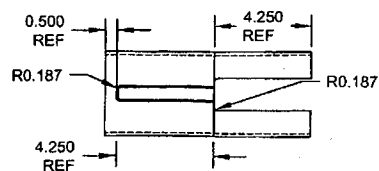
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SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
SCALE 2X

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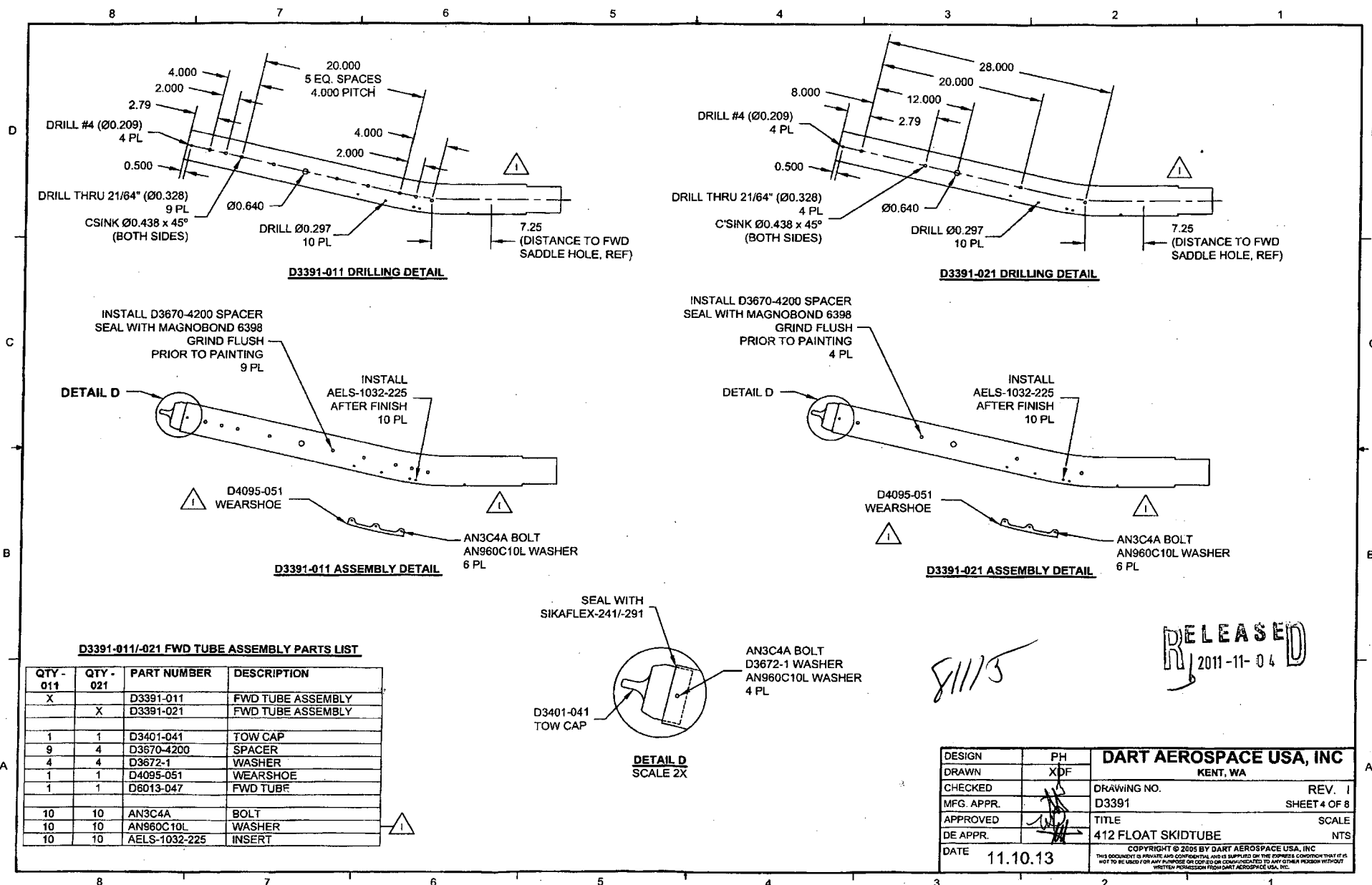
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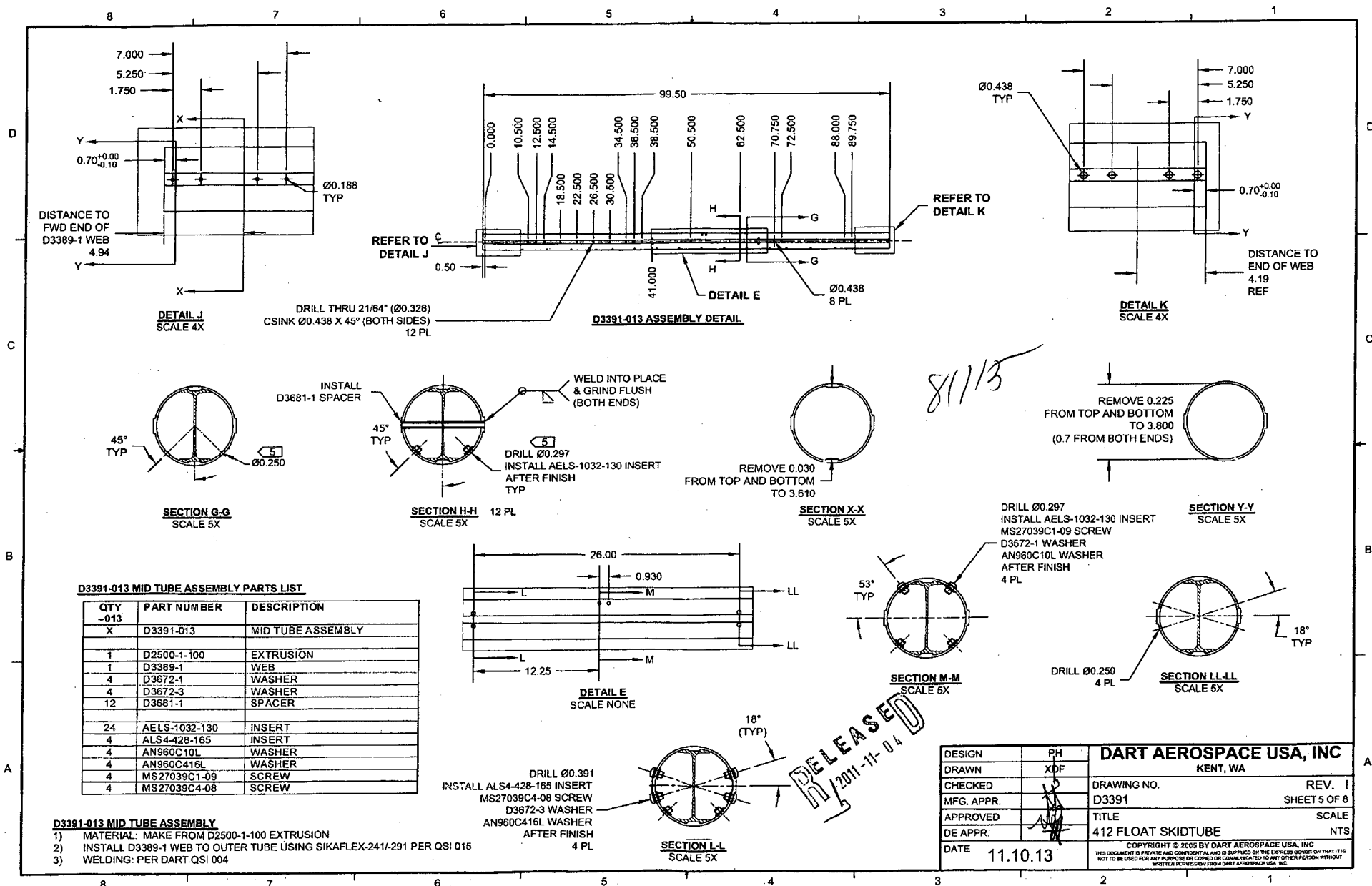
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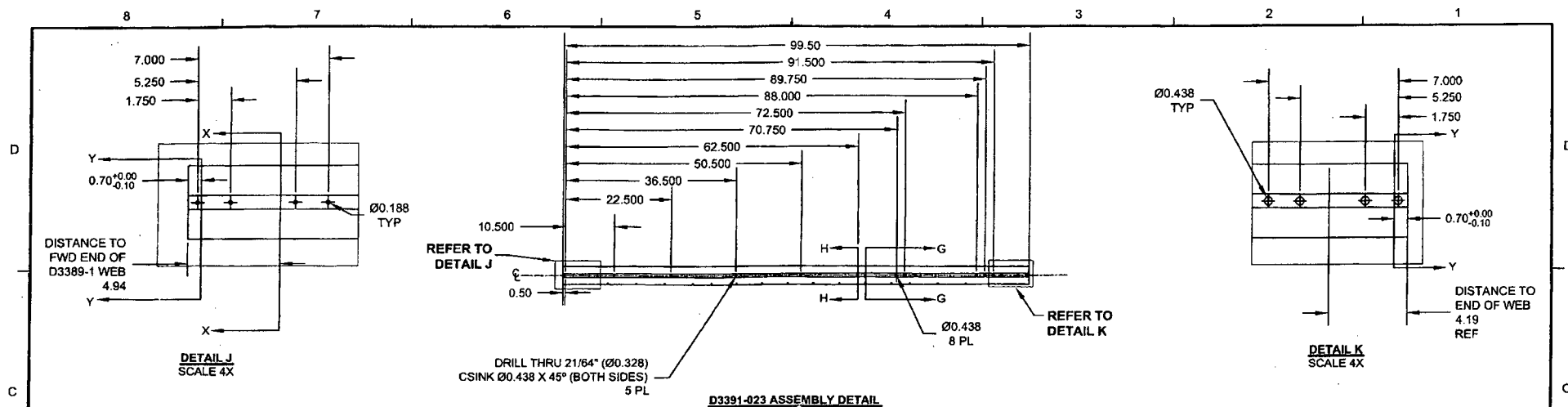
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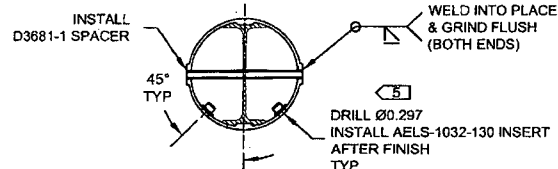
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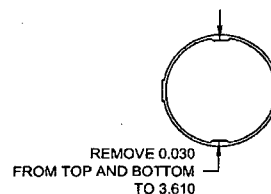
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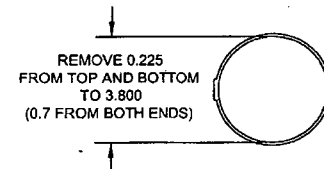
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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